

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009088**Date Inspected:** 19-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Yu Dong Ping, Chen Ying Xin, Li			<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No N/A
				<b>Delayed / Cancelled:</b>	Yes	No N/A

**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, West Tower, Struts.

SMAW welding of weld joint WD1-A6003-7-12A located on Bay11, West Tower. Welder is identified as 058009, 047470; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2212-TC-U5B.

Bay11, West Tower, Struts.

SMAW welding of weld joint WD1-A6003-4-17, 18; located on Bay11, West Tower. Welder is identified as 040655; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2113.

Bay10, South Tower, Internal Splice Plate.

FCAW welding of weld joint SSD1-SPSA3-56-4A/B; located on Bay10, South Tower. Welder is identified as 040345; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Bay10, East Tower, Struts.

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## WELDING INSPECTION REPORT

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SMAW welding of weld joint ED1-A6001-2-10A, 8B; located on Bay10, East Tower. Welder is identified as 068091, 069894; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Bay11, East Tower, Lift 3, DE Corner Triangular Plate.

FCAW Repair welding of weld joint ESTL3-4I/K-121 (CWR # T-CWR218); located on Bay11, East Tower. Welder is identified as 041271; ZPMC Quality Control Inspector (QC) is identified as Li Lin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-3G(3F)-REPAIR.

This QA Inspector carried out NDE on following:

Tower Jetty(Heavy Dock), East Tower.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

1)ESD1-SA233E/F-3, 4.

2)ESD1-SA237A/F-35, 36, 37, 38, 39.

This Notification (004343) is not been completed. ZPMC & AB/F informed that they have not finished there Inspection on rest of the Items on the Notification(Padeyes on all skins on both Lift 1 & 2). ZPMC agreed to renotify this Inspection.

Bay 11, West Tower, Lift 3, C/D Corner seam.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as WSTL3-4B/K-83A.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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